ARMSCOR

M16 R / M1600 R

USER'S MANUAL

WARNING:

READ THE INSTRUCTIONS AND SAFETY PRECAUTIONS IN THIS MANUAL CAREFULLY BEFORE USING THIS FIREARM.

DISCHARGING FIREARMS IN POOLY VENTILATED AREAS, CLEANING FIREARMS OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUSBSTANCES KNOWN TO THE STATE OF CALIFORNIA TO CAUSE BIRTH DEFECT, REPRODUCTIVE HARM AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATED AT ALL TIMES. WASH YOUR HANDS THOROUGHLY AFTER EXPOSURE.

OPERATING INSTRUCTIONS

This rifle is shipped from the factory fully assembled and ready to shoot. Clean the rifle from excessive oil and grease before using.

TO LOAD MAGAZINE: Hold the magazine box firmly with one hand and, with the other, place a cartridge into the magazine throat just in front of the supporting notch. Push the cartridge head down and rearward until it is securely locked in place. A maximum of fifteen rounds may be loaded.

TO ATTACH MAGAZINE: Push the magazine into the trigger guard housing opening, until the magazine locks in place.

TO DETACH MAGAZINE: Push magazine release forward until the magazine catch releases the magazine. Pull the magazine away from the trigger guard.

TO MAKE GUN SAFE: Safety lever is at the right side of the receiver and at the back of the bolt operating handle. Pull safety latch toward the "S" mark on the receiver. This locks trigger and gun cannot be fired.

TO LOAD CHAMBER: With the safety on, insert a loaded magazine into the rifle. Pull the bolt operating handle all the way to the rear and release, allowing the bolt to move forward under full force of the operating springs. Bolt automatically picks up a cartridge from the magazine and feeds it into the chamber. Do not ease bolt forward.

TO FIRE: Be sure gun is pointed at safe target. Release safety and pull the trigger. Pressure from the burning powder opens up bolt, ejects empty shell, and reloads the chamber for the next shot. Pull the trigger again. Gun fires as fast as trigger is pulled until magazine is empty.

TO UNLOAD WITHOUT FIRING: Draw safety on and release the magazine from guard. Work action several times to remove any cartridge left inside the chamber. Slide bolt handle rearward and lock piece. Inspect the chamber to make sure no cartridge is left. Empty magazine can be placed back if desired.

1. DISASSEMBLY

A. STOCK AND TRIGGER GUARD HOUSING

1. Remove the magazine by depressing the magazine catch.
2. Remove front screw of the trigger guard housing and detach barrel-receiver assembly from the stock.

B. TRIGGER GROUP

1. Trigger housing may be disassembled by unscrewing the two hold down screws. (This step is not advisable unless necessary)
2. Remove the trigger by punching out trigger stop pin and pivot pin.
3. Remove the trigger spring and spring follower at the end of the housing.

C. BOLT DISASSEMBLY

1. Loosen receiver cap lock screw and unscrew receiver cap. Be careful, as spring inside are under pressure.
2. Pull out the unit assembly (recoil spring, recoil spring retainer and guide sleeve, firing pin spring, firing spring pin spring guide head and stem). Keep in order together with the receiver cap to avoid confusion in re-assembly.
3. With muzzle pointing upwards, fully retract bolt handle fully to the rear end of the receiver slot.
4. Push firing pin forward so as to align its tail end approximately even with the receiver cap lock screw. (Firing pin in visible and is even with the rear end of the bolt).
5. Pull out bolt handle and operating stud and remove bolt from the receiver.

II. **DISASSEMBLY**

A. BOLT ASSEMBLY

1. Place firing pin at the rear end of firing pin slot in the bolt.
2. Push bolt and firing pin into the receiver and align bolt, firing pin and receiver holes so that bolt handle may be inserted through. Slide bolt forward with bolt handle until bolt stops against the rebound lever.
3. While holding the trigger back with one hand, use a nail or any pointed object to trip the rebound lever, moving it to the rear away from sear in the direction indicated by an arrow on the rebound lever. (See small sketch engrave in the trigger housing).
4. Push bolt handle forward. Slide the bolt over the rebound lever. Release the trigger.

   Note: Steps 5 to 7 can be by-passed as long you follow instruction of step no.2 for bolt disassembly, keeping these components together and in order.
5. Insert recoil spring guide sleeve and retainer sleeve into the opposite end of the recoil spring.
6. Insert firing pin spring guide into the firing pin spring.
7. Insert assembly no.6, spring end first, into the recoil spring through the guide spring sleeve (shorter sleeve).

8. Insert the entire unit inside the receiver, shorter sleeve resting against the bolt together with the receiver cap and compress the springs carefully to return the receiver cap into its original position. Tighten the receiver cap lock screw.
9. Pull bolt handle back and forth several times to check the action of the bolt and trigger assembly.

B.TRIGGER ASSEMBLY

1. With gun in an upside down position, insert trigger spring follower into the trigger spring and mount it into the spring hole.
2. Insert the trigger, locating the catch of the rebound lever, with the rear catch.
3. Insert the trigger stop pin and pivot pin into their respective holes.
4. Squeeze trigger several times to check the action of trigger spring. (Pull bolt handle back and forth several times to check the trigger release cocked firing pin).

CAUTION:

The safety in your firearm is correctly designed, fitted and tested. However, any mechanical device can fail. Never point your firearm at anything but a safe target and never rely upon the safety to justify careless handling. USE HIGH VELOCITY .22 CALIBER LONG RIFLE CARTRIDGES ONLY.

When loading, pull bolt handle fully rearward and allow it to snap forward sharply. Breech area and magazine should be cleaned thoroughly.

SPECIFICATIONS

Model	16.22 LR Semi- automatic Rifle
Barrel Length	18 inches
Weight	6.5 lbs.
Overall Length:	38.375 inches
Magazine Capacity:	15 rounds
Sights	Fixed Peep Rear Sight; Post Sight
Stock:	Black Finish wood

Safety Position Thumb Operated Safety

PART NAME	PART NUMBER
A) BARREL RECEIVER ASSEMBLY	
Barrel Receiver Cross Pin	1601
Barrel	1602
Ejector	1603
Muzzle Brake	1604
Muzzle Brake Set Screw	1605
Front Sight	1606
Front Sight Stud	1607
Front Sight Stud Lock Screw	1608
Front Sight Set Screw	1609
Rear Sight Carrying Handle	1610
Rear Sight Carrying Handle Screw	1611
Rear Sight Carrying Handle Lock Screw	1612
Rear Sight Leaf	1613
Rear Sight Screws (two pieces)	1614
Flash Deflector	1615
Receiver	1616
Receiver Cap	1617
Receiver Cap Lock Screw	1618
B) BOLT ASSEMBLY	
Bolt	1619
Bolt Operating Handle	1620
Bolt Operating Stud	1621
Bolt Handle Locating Bearing	1622
Bolt Handle Locating Spring	1623
Extractor	1624
Extractor Plunger	1625

Extractor Spring	1626
Firing Pin	1627
Firing Pin Spring	1628
Firing Pin Spring Guide Head and Stem	1629
Firing Pin Spring Guide Head Insert	1629a
Recoil Spring	1630
Recoil Spring Guide Sleeve	1631
Recoil Spring Retainer Sleeve	1632

C) TRIGGER HOUSING ASSEMBLY

Magazine Catch	1633
Magazine Catch Button	1634
Magazine Catch Pivot Pin	1635
Magazine Catch Stop Pin	1635a
Magazine Catch Stop Spring	1635b
Safety Latch	1636
Safety Latch Button	1637
Safety Latch Bearing	1638
Safety Latch Spring	1639
Safety Latch Screw	1640
Sear	1641
Sear Pivot Pin	1642
Sear Stop Pin	1643
Sear Spring	1644
Sear Spring Pin	1645
Trigger	1646
Trigger Pivot Pin	1647
Trigger Stop Pin	1648
Trigger Spring	1649
Trigger Spring Follower	1650
Rebound Lever	1651

Rebound Lever Pivot Pin	1652
Rebound Lever Safety Pin	1653
Rebound Lever Spring	1654
Rebound Lever Spring Bearing	1655
Trigger Housing	1656
Trigger Housing Hold Down Screw (front)	1657
Trigger Housing Hold Down Screw Washer (front)	1657a
Trigger Housing Hold Down Screw (rear)	1658
Trigger Housing Hold Down Screw Washer (rear)	1658a

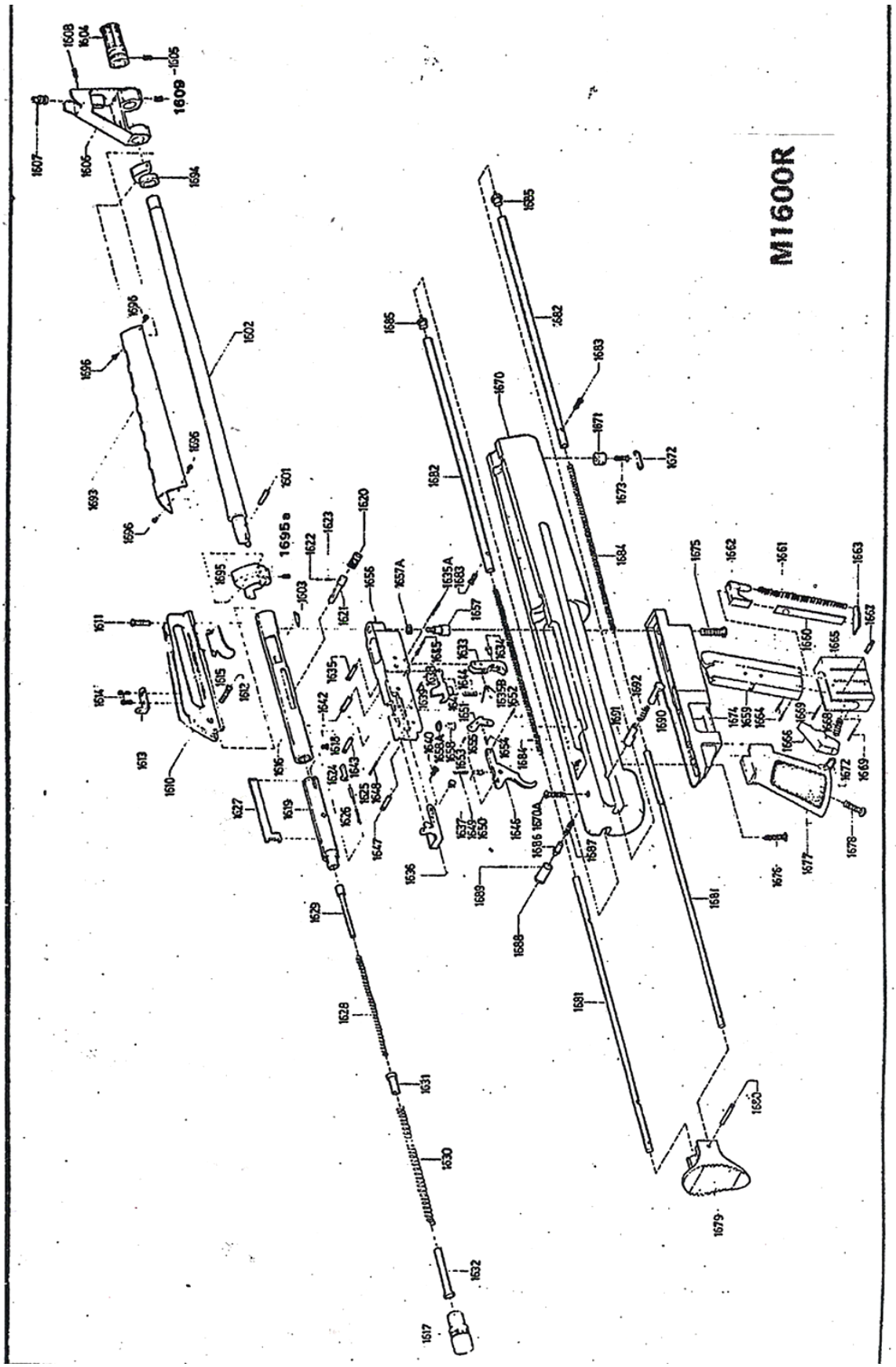
D) MAGAZINE BOX ASSEMBLY

Magazine Box	1659
Magazine Box Inner Strip	1660
Magazine Spring	1661
Magazine Spring Follower	1662
Magazine Spring Retainer	1663
Magazine Spring Retainer Pin	1664
Magazine Cover	1665
Magazine Release	1666
Magazine Release Pivot Pin	1667
Magazine Release Spring	1668
Magazine Box Retainer Pin (two pieces)	1669

E) GUNSTOCK ASSEMBLY

Gun stock	1670
Crack preventive Screw	1670a
Swivel Head (two pieces)	1671
Swivel Ring (two pieces)	1672
Swivel Screw (two pieces)	1673
Trigger Guard Housing	1674
Trigger Guard Screw (front)	1675
Trigger Guard Screw (rear)	1676

Grip	1677
Grip Screw	1678
Butt Stock	1679
Butt Stock Retainer Pin	1680
Butt Block Extension Rod (two pieces)	1681
Extension Rod Housing (two pieces)	1682
Extension Rod Housing Hold Down Screw (two pieces)	1683
Extension Rod Spring (two pieces)	1684
Extension Rod Spring Retaining Plug (two pieces)	1685
Extension Rod Stop Button (left)	1686
Extension Rod Stop Button Spring	1687
Extension Rod Stop Button Bushing	1688
Extension Rod Stop Button Spring Retainer Pin	1689
Extension Rod Release Button	1690
Extension Rod Release Button Bushing	1691
Extension Rod Release Button Spring	1692
Barrel Hood	1693
Barrel Hood Ring Block (front)	1694
Barrel Hood Ring Block (rear)	1695
Barrel Hood Ring Retainer Set Screw	1695a
Barrel Hood Retainer Screws (four pieces)	1696


M1600R